

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025070**Date Inspected:** 06-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As listed below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 9E PP79 E4 Lifting Lug Access Holes #1 and 3
2. 9E PP80 E3 Lifting Lug Access Hole #2
3. 10E 11E F Plate Splice
4. 9E PP71 Drip Rails
5. 11E 12E A2 R1/A3 R1

1. 9E PP79 E4 Lifting Lug Access Holes #1 and 3

The QA Inspector observed ABF welder Mike Jiminez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole's (LLH) #1 and 3 located at 9E PP79 E4. Prior to welding the QA Inspector observed QC Inspector Fred Von Hoff inspecting the fit up of the joint and the QA Inspector verified the fit up alignment of the two access holes which were deemed acceptable as pertaining to the contract requirements. The QA Inspector observed the QC Inspector monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

2. 9E PP80 E3 Lifting Lug Access Hole #2

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The QA Inspector observed ABF welder Jorge Lopez ID# 6149 performing SMAW in the 1G flat position on Lifting Lug Hole (LLH) #2 located at 9E PP80 E3. Prior to welding The QA Inspector observed QC Inspector Fred Von Hoff inspecting the fit up of the joint and the QA Inspector verified the fit up alignment of the access hole which was deemed acceptable as pertaining to the contract requirements. The QA Inspector observed the QC Inspector monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

3. 10E 11E F Plate Splice

The QA Inspector observed ABF welder Wen Han Yu ID# 6317 performing SMAW in the 3G verticle position on Plate Splice F located at 10E 11E F1. The QA Inspector observed the QC Inspector Fred Von Hoff monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1040A. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

4. 9E PP71 Drip Rails

The QA Inspector made periodic observations of ABF welder Fred Kaddu ID# 2188 performing SMAW in the 2G horizontal position on Drip Rails located outside of the OBG at 9E PP71.9-72.1 and PP73.9- PP74.1. The QA Inspector observed the QC Inspector Pat Swain monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1200A Rev. 2. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

5. 11E 12E A2 R1/A3 R1

The QA Inspector observed QC Inspectors John Pagliero and Jesse Cayabyab perform Shear Wave Ultrasound Testing on 11E 12E A1 – A5. It was noted by the QA Inspector that rejectable indications were found at six (6) locations on A2 and four (4) locations on A3. Upon completion of the testing, the QA Inspector observed ABF welder Rick Clayborn ID#2773 excavate the sites and commence repairs. The QA Inspector recorded the dimensions of the excavations and observed QC Inspector John Pagliero monitor the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1200A Rev. 2. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

Summary of Conversations:

At the beginning the shift the QA Inspector met with QC Inspector Pat Swain and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer